

Work Order ID 71144

Thursday, June 23, 2011 12:35:03 PM

Page 1

Item ID: D3644-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Shim

Start Date: 6/23/2011 Start Qty: 8.00

Cust Item ID:

Required Date: 7/5/2011 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: UMF

Date: 11-06-23 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3644	Rev A								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3644 11Dwg Rev: A 11Prog Rev: 1A 112-
Deburr if necessary

2024.050

B11-6-27

(10)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-6-27

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sub 6/27

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Item Name: Shim

Start Date: 6/23/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/5/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10x Ø M-11/06/27

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10/1/06/28 (10)

150

Identify as per dwg & Stock Location: 274A

0.00



Packaging

Memo

0.00

Packaging

10/1/06/28 (10)

W/O:		WORK ORDER CHANGES					
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Page 3

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Accept



Setup Start



Revision ID:

Stop



Item Name: Shim

Start Date: 6/23/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/5/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/28

11-06-28
(10)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Thursday, June 23, 2011 12:35:01 PM

Page 1

Work Order ID: 71144



Parent Item: D3644-1



Parent Item Name: Shim

Start Date: 6/23/2011

Required Date: 7/5/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.050

Purchased

No

110

sf

116.3000

0.1664

1.401263

1.4



B116-07

2024-T3 .050 sheet

Location

Loc Qty

Loc Code

MAT22

116.3

117684

116.3

117684

10

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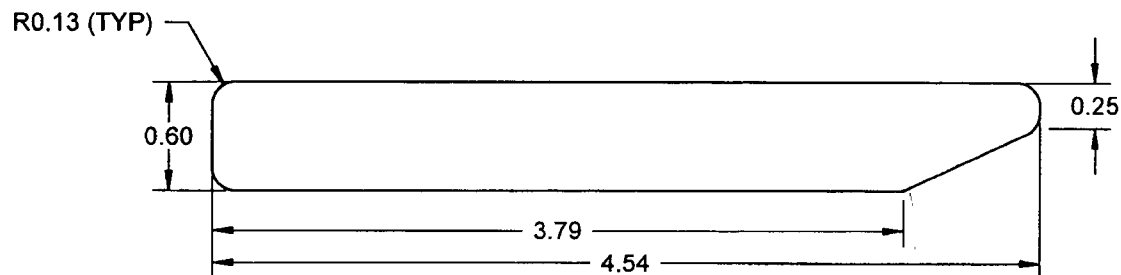
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D3644-1 SHIM
(REPLACES GENEVA P/N G10610-3)

71144

RELEASED
 07.09.07 #

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3644-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.01lbs

A	NEW ISSUE; REPLACES G10610-3		LE	07.07.27
REV.	DESCRIPTION		BY	DATE
DESIGN	DTI	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
DRAWN	CE			
CHECKED	BE	DRAWING NO.	REV. A	
MFG. APPR.	BE	D3644	SHEET 1 OF 1	
APPROVED	MP	TITLE	SCALE	
DE APPR.	SH	SHIM	1:1	
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

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